Date:

Thursday, 16/11/2006 9:46:51 AM

Linda Lacelle

## **Process Sheet**

**Drawing Name** 

Part Number

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29382D

**Estimate Number** 

P.O. Number

This Issue

**Previous Run** 

: 16/11/2006

: NC

Prsht Rev. First Issue

: 09/11/2006

Type

: 24956D

Written By Checked & Approved By

Comment

: Est Rev: A

New Issue 05-11-06 JLM

S.O. No. : NIA

: MACHINED PARTS

Material

**Due Date** 

: N/A

: D32203

: D3220 REV A1

: DOUBLER

: NIA : 05/12/2006

Qtv:

Each

**Additional Product** 

Job Number:



Seq. #:

1.0

**Machine Or Operation:** 

**Description:** 

M2024T3S050

2024-T3 .050 sheet



Comment: Qtv.:

0.6233 sf(s)/Unit Total:

9.9725 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050 Identify for D3220-3 Batch: <u>H19053</u>

WATER JET

FLOW WATER JET



CAP?

**Comment: FLOW WATER JET** 

3.0

2.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



SECOND CHECK



4.0



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1





Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



Page 1

Form: rprocess

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHA	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· · · · · ·							
Part No	•	PAR #: Fault Category:	NCR: Yes	No DO	A:	Date: 0	<u> </u>

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC		Corrective Action Section B			Approval	
		Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Verification Section C	Chief Eng	Approval QC Inspecto
						· .		
							•	
· · · · ·						:4	10	

NOTE: Date & initial all entries

Date:

Thursday, 16/11/2006 9:46:52 AM

Øser:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: DOUBLER

Job Number: 29382D

Part Number: D32203

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



8.0 QC21





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 06.12.05

## **Dart Aerospace Ltd**

		· <del></del> .								
<b>W</b> /O:			WC	ORK ORDER CHANG	SES					
DATE STEP		PROC	EDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	R: Yes	No DQA	<b>\</b> :	Date:	· · · · · · · · · · · · · · · · · · ·
						QA: N/	C Closed	<b>i</b> :	_ Date:	
NCR:		W	ORK ORDI	ER NON-CONFORM	ANCE	(NCR)	)			
DATE	STEP	Description of NC	L	- ·. ··	tion B	0: 0	Verific		Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
								,		

NOTE: Date & initial all entries

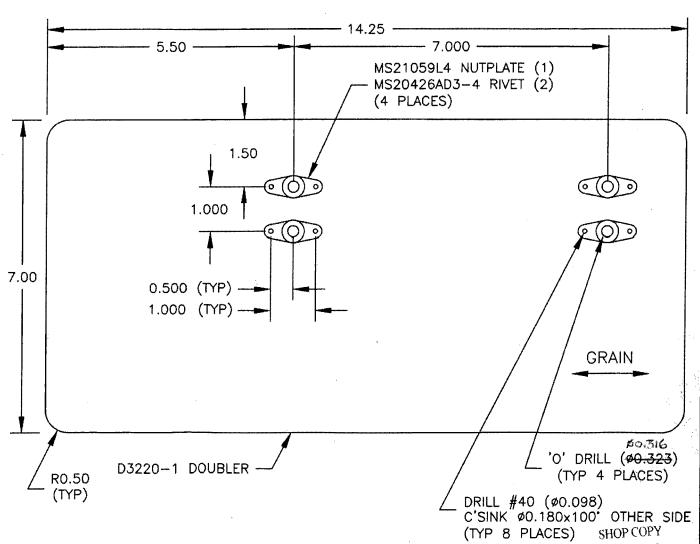
DART AEROSPACE LTD	Work Order:	29382D
Description: Doubler	Part Number:	D3220-3
Inspection Dwg: D3220 Rev: A1		Page 1 of 1

Inspection Dwg:	D3220 Re	v: A1				Pa	ige i oi i	
		ST ARTICLE II	NSPECTI	ON CHE	ECKLIST			
	X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments	
6.94	+/-0.030	6,949	~		Vern			
12.32	+/-0.030	12.31	/		Vern			
R0.20	+/-0.030	10.20	-		R-G			
0.050 thick	+/-0.005	0,049	V		Vern			
Grain Direction	N/A		ok					
				-				
	<u> </u>							
							· · · · · · · · · · · · · · · · · · ·	
		Audited bee	kh		Prototype App	rovel	NI/A	
Measured by:	SAD	Audited by:	(K)	K-7	Prototype App		N/A	
Date: 0	8:11:25	Date:	06/11/6			Date:	N/A	
Poy Date Change Revised by Approve						Approvéd		

		•			
Rev	Date	Change		Revised by	Approv∉d
Α	04.02.27	New Issue	P/O D412-698-013	KJ/RF	
		,			/ /



DESIG	in #	DRAWN BY		AEROSPACE LTD KESBURY, ONTARIO, CANADA	
CHEC	KED M	APPROVED	DRAWING NO.		REV. A
	#	#	D3220	SHEET	1 OF 2
DATE			TITLE		SCALE
03.	10.16		DOUBLER		1:2
Α		03.10.16	NEW ISSUE		
AI	CP H	03.11.13	CORRECTED	0 m	



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER) RETURN TO ENGINEERING 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK

(REF DART SPEC. M2024T3S.090)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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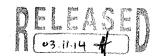
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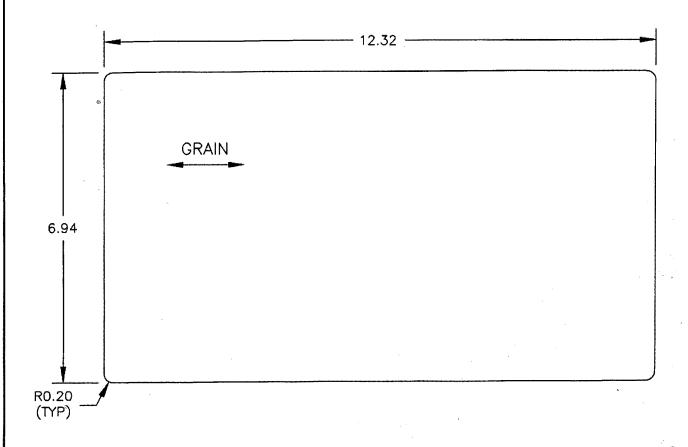
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DESIGN	DRAWN BY		ROSPACE LTD y, ontario, canada
CHECKED	APPROVED,	DRAWING NO.	REV. A
1 9	1	D3220	SHEET 2 OF 2
DATE		TITLE	SCALE
03.10.16		DOUBLER	1:2





D3220-3 DOUBLER

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M2024T3S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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